

Work Order ID 75412

October-21-11 11:48:46 AM

75412

Page 1

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 21/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 02/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J. Date: 11/10/21

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod M117884/M118736

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

SAD 11-11-07

BEU 11/07

BEU 11/07

11/11/08

SAD 11-11-08

Dart Aerospace Ltd

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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.

****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

S. 11/11/09

SAD 11-11-08

DC 11/11/08

Dart Aerospace Ltd

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

Dart Aerospace Ltd

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 Required Date: 02/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00			11-11-9				
180 *180* Skidtubes Skidtubes	Skidtubes Memo 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting Start Date: <u>11/11/09</u> Time: <u>4:15</u> Finish Date: <u>11/11/10</u> Time: <u>10:00</u> Pick: Qty Part Number Description Batch A/RSikaflex-291 <u>119399</u> Sikaflex expire date: <u>12/08/13</u>	0.00 0.00							

Dart Aerospace Ltd

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Stop *NS2*

Start Date: 21/10/2011 **Start Qty:** 1.00 ***1***

Required Date: 02/11/2011 **Req'd Qty:** 1.00 ***1***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp. Stamp

0.00

190

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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1

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod M 117884

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONEBE 11-11-11

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

DP 11-11-14

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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75412

October-21-11 11:48:46 AM

N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Dart Aerospace Ltd

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 Start Date: 21/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 02/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									

240	Pressure Wash per QSI005 4.3	0.00							
240									
HandFinish	Memo	0.00							
Hand Finishing									

250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
250									
Powdercoat	Memo	0.00							
Powder Coating									

M118434

9:30
 START TIME: 32:00
 OVEN TEMPERATURE: 10:00
 FINISH TIME:

IX 0 M-L 11/11/14

IX 0 M-L 11/11/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	HandFinishing	0.00							
270									
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

PH

Dart Aerospace Ltd

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280		0.00							
280	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 <u>1119443</u> Sikaflex expire date: <u>1216</u>								
	2- Install wearplate as per dwg								
	2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: <u>11118980</u>								
290	QC3- Inspect Part Finish	0.00							
290									
QC	Memo	0.00							
Quality Control									

121 4 111130

11 11 30 (1)

Dart Aerospace Ltd

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300	QC5- Inspect part completeness to step on W/O	0.00							
300									
QC	Memo	0.00							
Quality Control									
310	Packaging	0.00							
310									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-151								
	Location: _____								
	PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

Handwritten notes and stamps:
11 - 11 - 30 (1)

Handwritten signature and date:
11/11/30

Handwritten signature and date:
11/12/11

Handwritten note:
N. 11/11/30

Dart Aerospace Ltd

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Picklist Print

October-21-11 11:48:50 AM

Page 1

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 10.12.08 PER IIN REV:N DD VERF:EC
REV:B 11.09.16 PER IIN REV:O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured

No

110

Each

13.0000

1

1

D2620

Skidtube, 206 Skidtube

**

SAD 17/11/07

Location

Loc Qty

Loc Code

LG

13

71616

3

71617

6

73783

1

73785

1

73786

2

B72459

①

D2647

Manufactured

No

110

Each

199.0000

1

D2647

Cap

**

BEU/11/07

Location

Loc Qty

Loc Code

LG002

199

55352

4

71171

11

73826

184

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

18,966.00

52

52

CR3212-4-04

Cherry Rivet

Location

Loc Qty

Loc Code

ST311

150

116471

78

117816

3

118686

1

118840

68

st510

10000

119075

10000

ST516

8816

119017

8816

D2654-1

Manufactured

No

180

Each

4.0000

1

1

D2654-1

Web

Location

Loc Qty

Loc Code

LG

4

73794

4

D3286-1

Manufactured

No

180

Each

110.0000

2

2

D3286-1

Doubler

Location

Loc Qty

Loc Code

LG002

110

74141

22

74441

88

DC 11/11/09

DC 11/11/09

SAD 11-11-09

Q

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

October-21-11 11:48:50 AM

Work Order ID: 75412

75412

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

1,184.000

19

19

D2649

Cross Bolt Spacer

**

BE 11/11/10

Location

Loc Qty

Loc Code

LG

617

68224

2

71355

2

72704

2

72841

11

73855

600

19

LG001

567

65317

1

68507

11

73390

8

73857

21

73860

526

D3286-3

Manufactured No

200

Each

101.0000

2

2

D3286-3

Spacer

**

BE 11-11-11

Location

Loc Qty

Loc Code

LG001

101

74117

21

74439

80

2

D2680-041

Manufactured No

210

Each

99.0000

1

1

D2680-041

Nut Plate

**

11-11-11

Location

Loc Qty

Loc Code

LG

4

73334

4

ST020

95

73854

95

1

October-21-11 11:48:51 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

October-21-11 11:48:51 AM

Page 4

Work Order ID: 75412

75412

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

210

Each

2,010.000

2

2

CR3212-4-03

Cherry Rivet

**

DD 11-11-14

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1008

114859

1008

ST318

1000

119017

1000

AN960JD416

~~NAS1149D0463L~~ Purchased

No

210

Each

0.0000

1

1

AN960JD416

Washer

**

1118384 (K1) 11/11/14

CCR264SS3-3

Purchased

No

210

Each

1,285.000

2

2

CCR264SS3-3

Cherry Rivet

**

DD 11-11-14

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

283

117849

283

ST317

1000

119017

1000

MS27039-4-06

Purchased

No

210

Each

433.0000

1

MS27039-4-06

Screw

**

11/11/14

Location

Loc Qty

Loc Code

ST292

433

119075

400

119124

33

X1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 75412

75412

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No

270 Each 1,063.000 6 6

D2651-1

Plug

**

Handwritten: 11/11/16

Location	Loc Qty	Loc Code
fpa	2	
69018	2	
FP-A	1061	
57869	1	
66445	10	
70839	2	
71037	31	
73827	1017	

D2651-3 Manufactured No

270 Each 1,547.000 6 6

D2651-3

O-Ring

**

Handwritten: 11/11/16

Location	Loc Qty	Loc Code
FP-A	1547	
61962	12	
66956	30	
73489	505	
73828	1000	

D3873-1 Manufactured No

280 Each 342.0000 14 14

D3873-1

Bushing

**

Handwritten: 11/11/16

Location	Loc Qty	Loc Code
ST088	342	
64760	1	
68247	4	
73829	19	
73831	318	

Handwritten: B73830

Handwritten: x14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

October-21-11 11:48:51 AM

Page 6

Work Order ID: 75412

75412

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280

Each

91.0000

1

1

D2646

Aft Cap

**

u u u u u

Location

Loc Qty

Loc Code

FP002

60

73294

60

Y1

FP004

17

68280

17

FP006

5

62678

5

FP-4

5

70945

1

71070

4

fp5

4

71038

4

D3805-041

Manufactured No

280

Each

0.0000

1

1

D3805-041

Wearplate Assembly Fwd, Low Gear

MS27039-1-08

Purchased No

280

Each

1,971.000

2

2

MS27039-1-08

Screw

**

B76410 (x1) u u u (30)

**

u u u u u

Location

Loc Qty

Loc Code

ST291

1971

117423

155

118378

316

v2

118910

500

119075

500

119109

500

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 7

Work Order ID: 75412

75412

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

280

Each

9,976.000

7

7

MS21042L3

Nut

**

Handwritten: 11/11/11

Location

Loc Qty

Loc Code

ST300

976

117441

16

117885

87

118451

179

118927

694

ST516

6000

119017

6000

ST518

3000

119075

3000

Handwritten: x7

D3805-045

Manufactured

No

280

Each

5.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

Handwritten: 1374938 (x1) 11/11/11

Location

Loc Qty

Loc Code

FP

5

73817

5

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

AN960JD10L

Washer

**

Handwritten: 1117087 (x1) 11/11/11

*Handwritten: **

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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October-21-11 11:48:51 AM

Work Order ID: 75412

75412

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 21/10/2011

Required Date: 02/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No 280 Each 2,319.000 7 7
AN3-37A ** ml 11/11/11
Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST353	269	
111668	169	
118628	100	
ST354	50	
117619	50	
ST518	2000	
<u>119086</u>	2000	

NAS1149D0363J Purchased No 280 Each 2,836.000 7 7
NAS1149D0363.J ** ml 11/11/11
Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	2836	
117601	218	
118077	135	
118612	483	
<u>118968</u>	2000	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 75412 M.L.J
11/10/21

RELEASED
UP 09.03.03
per EEN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.07		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3804 REV. A
SHEET 1 OF 5

TITLE SKIDTUBE ASSEMBLY, 206A/B SCALE NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

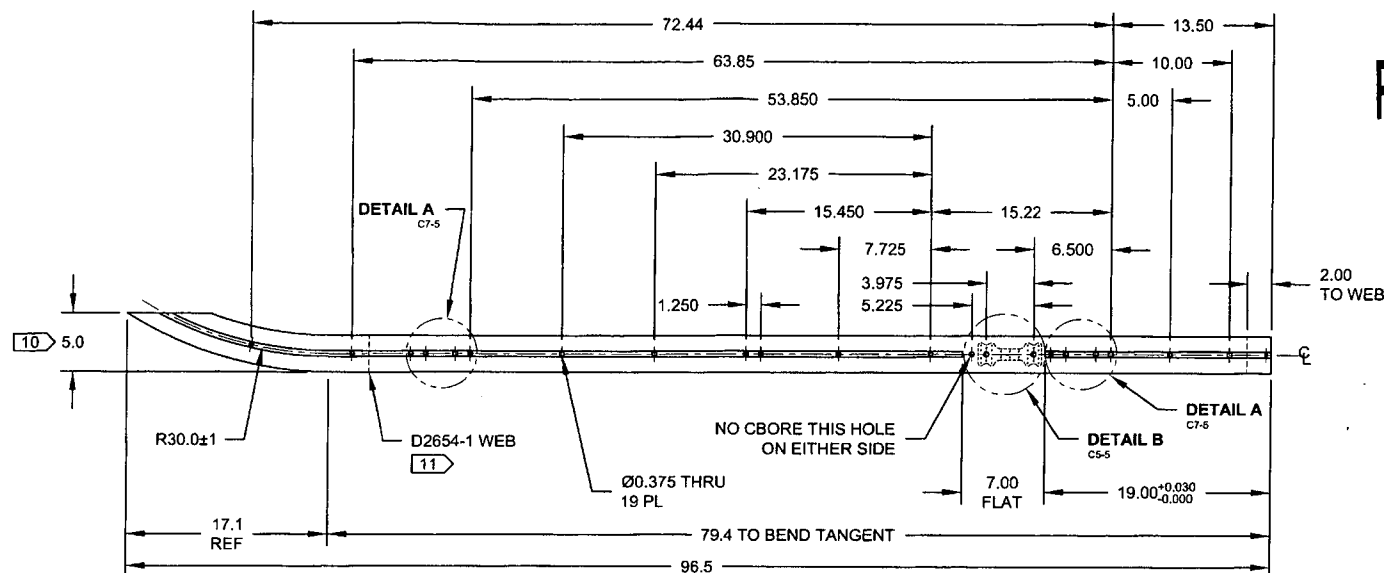
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

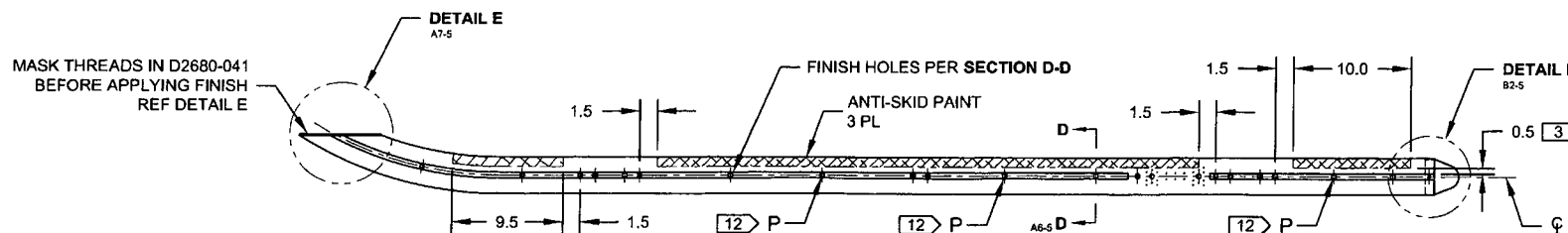
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75412

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	EE	D3804	SHEET 2 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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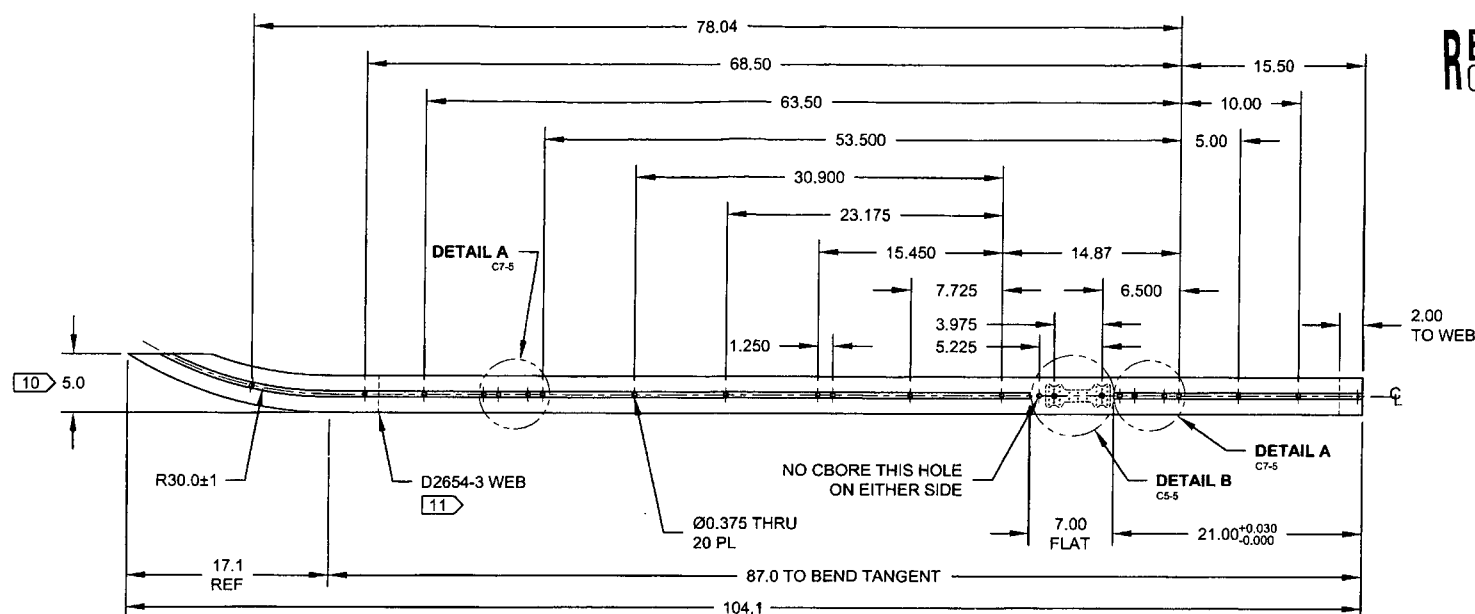
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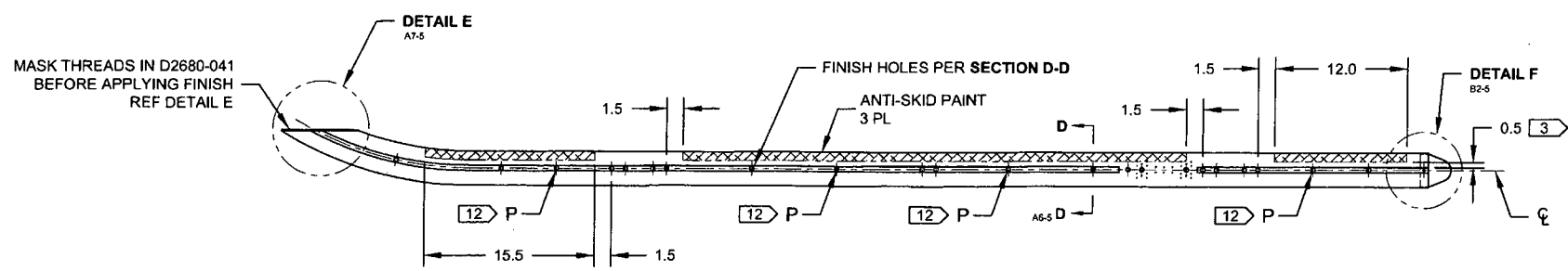
NOTE: Date & initial all entries

75412

RELEASED
09-03-03



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

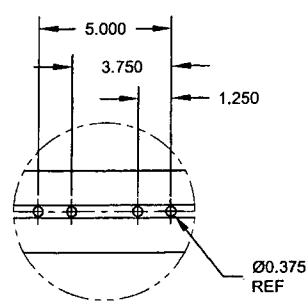
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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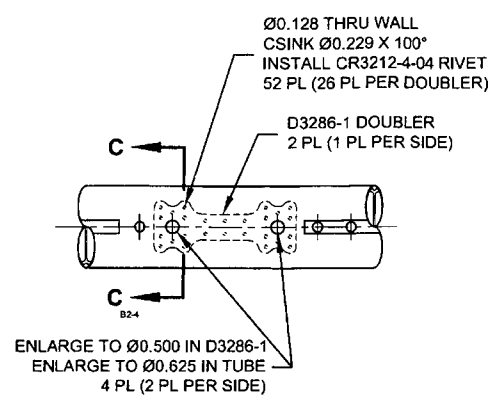
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75412

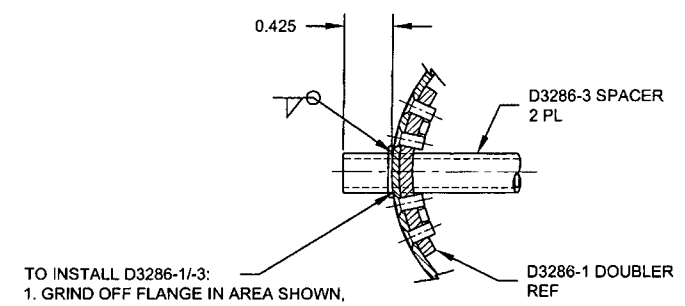
RELEASED
09.03.07



DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

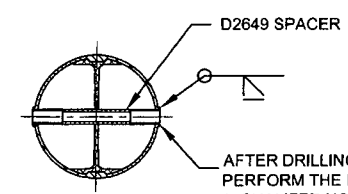


DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	B	D3804	SHEET 4 OF 5
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Dart Aerospace Ltd

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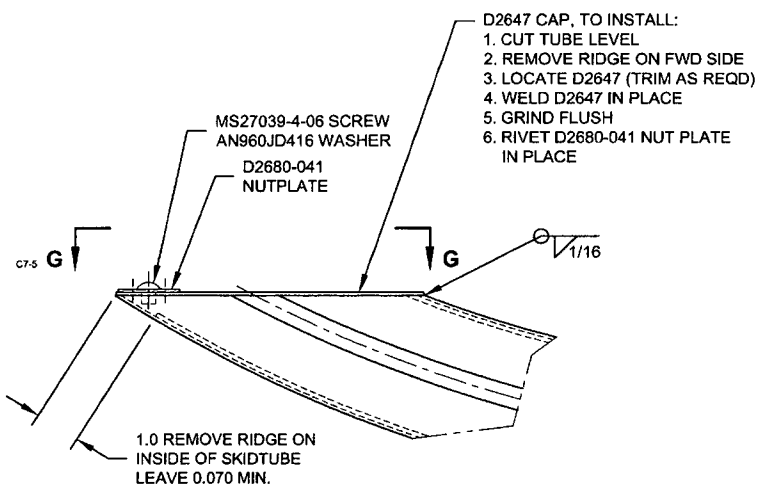
NOTE: Date & initial all entries

75412

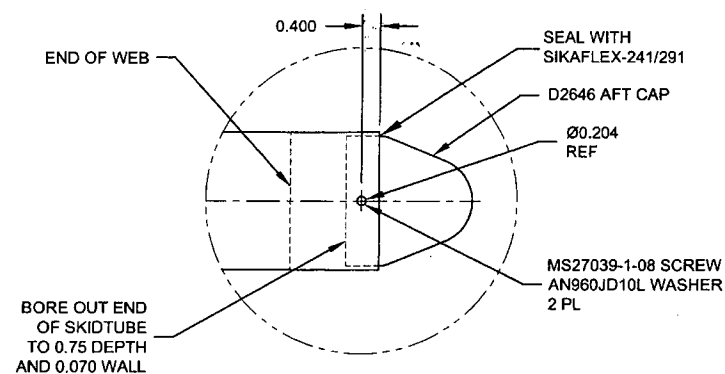
RELEASED
97 09.03.03

VIEW G-G
SCALE NONE

A7-5



DETAIL E
SCALE NONE

B7-2
B7-3

DETAIL F
SCALE NONE

B2-2
B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 273

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 74236
Part number: D206 642 151
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Sal. Lunn Date of Test Coupon 11-10-25
Welder Barclay Elliott Date of Test Coupon 11-10-25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld